

Work Order ID 103702

\*103702\*

Page 1

June-25-13 7:33:18 AM

Item ID: D212-725-1-123

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/25/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/26/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: W Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4235	A
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110		0.00							
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\*110\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg  
Dwg Rev: A  
Prog Rev: A  
2-Deburr if necessary

0.00

0 ET 13-6-25

120	QC8- Inspect parts - second check	0.00							
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\*120\*

QC

Quality Control

Memo

0.00

0 ET 13-6-25

130	QC2- Inspect parts off machine FAI/FAIB	0.00							
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\*130\*

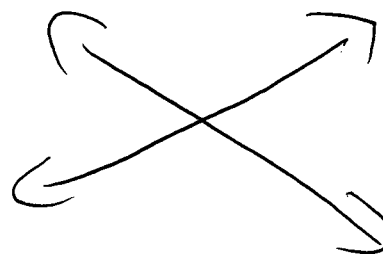
QC

Quality Control

Memo

0.00

0 ET 13-6-25



# Work Order ID 103702

\*103702\*

Page 2

June-25-13 7:33:18 AM

Item ID: D212-725-1-123

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/25/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/26/13 Req'd Qty: 1.00 \*1\*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Form as per dwg

0.00

\*140\*

Brake NC

Memo

0.00

Brake NC

AND FLANGE HOLES AFTER BEND AS PER DWG

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

\*160\*

HandFinish

Memo

0.00

Hand Finishing

SP 13/07/12

DAS 16 13/07/12

70

1 1613-72

# Work Order ID 103702

June-25-13 7:33:18 AM

\*103702\*

Page 3

Item ID: D212-725-1-123

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/25/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/26/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 QC7-Inspect Chemical Conversion Coat 0.00

\*170\*

QC Memo 0.00

Quality Control

DAS  
05  
9-89 13-07-02

180 0.00

\*180\*

SprayPaint  
Spray Painting

Memo  
PRIME and PAINT as per dwg

PRIMER BATCH: \_\_\_\_\_  
PAINT BATCH: \_\_\_\_\_

N/A - CAGLE WILL PAINT  
WP 13/07/02

DAS  
05  
9-89 13-07-02

190 QC14- Inspect Spray Paint 0.00

\*190\*

QC Memo 0.00

Quality Control

13-07-02

13-07-03

# Work Order ID 103702

June-25-13 7:33:18 AM

\*103702\*

Page 4

Item ID: D212-725-1-123

Accept:

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/25/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 6/26/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: _____	0.00							
*200*									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
*210*									
QC	Memo	0.00							
Quality Control									

1 2 13-7-03

13/7/3

W 13-07-03



# Picklist Print

June-25-13 7:33:18 AM

Page 1

Work Order ID: 103702

Parent Item: D212-725-1-123

Start Date: 6/25/13

Required Date: 6/26/13

Parent Item Name: Bracket

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			110	sf	556.5489	2.597	2.7336842			

EL 13-6-25

Location	Loc Qty	Loc Code
MAT022	556.5489	
119916	0.2	
121197	21.34	
123096	11.4	
123654	11.64	
<u>123701</u>	49.5289	
125341	89.44	
125636	373	

3.7

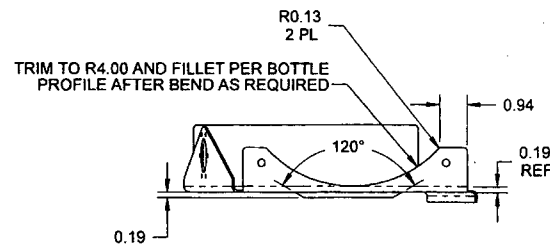
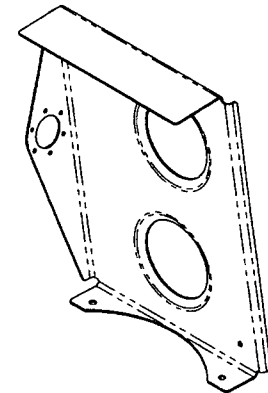
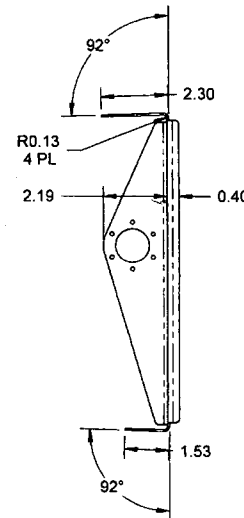
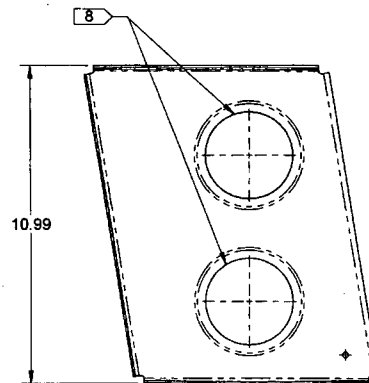
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	103702
<b>Description: Bracket</b>	<b>Part Number:</b>	D212-725-1-123F
<b>Inspection Dwg: D212-725-1 Pg 40 of 84 Rev: F</b>		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.140	+0.005/-0.001	0.140	✓		✓ JKM01	
Ø0.191	+0.005/-0.001	0.192	✓		"	
Ø1.165	+0.012/-0.001	1.167	✓		"	
7.70	+/-0.030	7.702	✓		✓ WJ02	
10.56	+/-0.030	10.56	-		T	
14.56	+/-0.030	14.58	✓		"	
5.05	+/-0.030	5.06	✓		JKM01	
1.270	+/-0.010	1.278	✓		"	
2.40	+/-0.030	2.404	✓			
4.24	+/-0.030	4.24	✓			
0.063	+/-0.010	0.064	✓			
Ø3.000	+0.012/-0.001	3.003	✓			

<b>Measured by:</b>	RL	<b>Audited by:</b>	DA 276	<b>Preliminary Approval:</b>	
<b>Date:</b>	13.6.25	<b>Date:</b>	13.6.26	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.11.15	New Issue	KJ	✓



**D212-725-1-123 BRACKET**  
(MAKE FROM D212-725-1-123F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D212-725-1-123F FLAT PATTERN
- 2) FINISH: PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) USE 3.0 FLANGE TOOL AFTER BEND, 2 PLACES

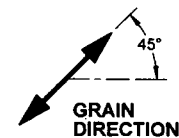
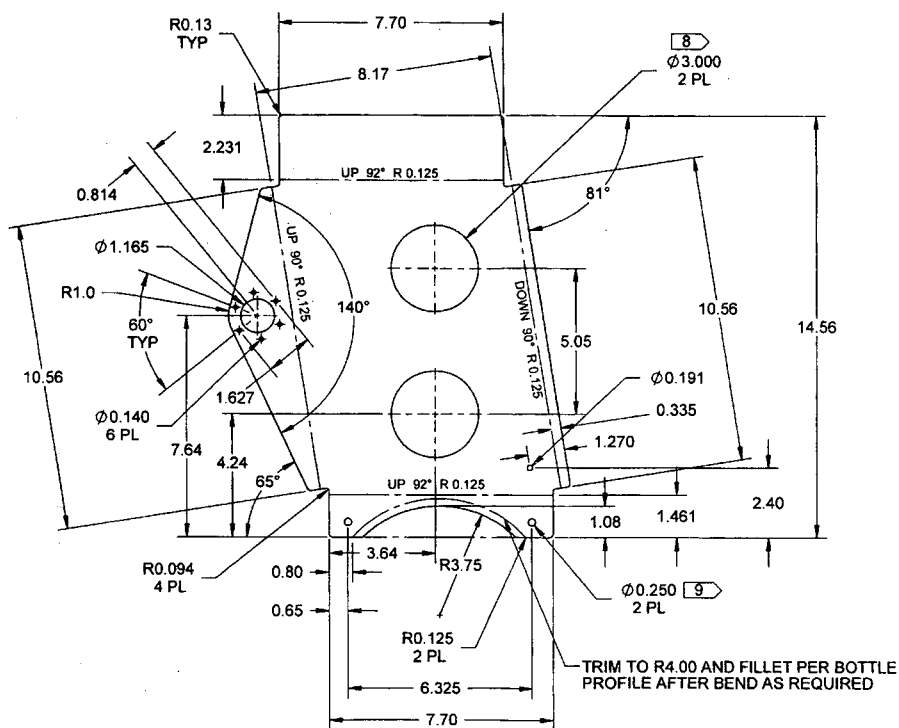
*also 103702*

**RELEASED**  
2011-08-25

A NEW ISSUE		RF	11.02.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4235	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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*84775*





# NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
REF DART SPEC. M2024T3S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.26 lbs
- 8) USE 3.0 FLANGE TOOL AFTER BEND, 2 PLACES
- 9) TRANSFER FROM AIRCRAFT FIRE EXTINGUISH BOTTLE

## D212-725-1-123F FLAT PATTERN

RELEASED  
2011-08-25  
W

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4235</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE <b>BRACKET</b>	SCALE NTS
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